

# Work Order ID 135718

Tuesday, August 18, 2015 8:18:52 AM

**\*135718\***

Page 1

Item ID: D4035-043 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Lid Rib Assembly, Aft (350 Basket)  
Start Date: 8/18/2015 Start Qty: 6.00 **\*6\*** Cust Item ID:  
Required Date: 8/18/2015 Req'd Qty: 6.00 **\*6\*** Customer:  
Reference:

Approvals: Process Plan: ML3 Date: AUG 18 2015 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D4035    | A            |

100 Weld per dwg A/R S.S. rod Batch: 4131417 0.00 **\*100\*** 6 **DAS 43 9-89** **AUG 18 2015**

Large Fab Memo 0.00  
Large Fab 1- Cut D4035-3 as per dwg D4035  
2- Drill holes using DT9563 and chamfer holes as per dwg D4035  
3- remove identification marks and deburr  
4- Weld bushing in rib and grind weld flush as per dwg D4035

110 QC10- Inspect visual per QSI004- ground welds 0.00 **\*110\*** 6x **DAS 24 9-89** **AUG 20 2015**  
QC Memo 0.00  
Quality Control

**Work Order ID 135718**

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Page 2

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                            | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number                       | Insp.<br>Stamp     |
|--------------------------------|-----------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|----------------------------------------|--------------------|
| 120                            | QC5- Inspect part completeness to step on W/O       | 0.00                 |         |        |              |               |               | <b>DAS</b><br><b>24</b><br><b>9-89</b> |                    |
| <b>*120*</b>                   |                                                     |                      |         |        |              | <u>6</u>      |               |                                        |                    |
| QC                             | Memo                                                | 0.00                 |         |        |              |               |               |                                        |                    |
| Quality Control                |                                                     |                      |         |        |              |               |               |                                        | <b>AUG 20 2015</b> |
| 130                            | Identify as per dwg & Stock Location: <u>WAB 04</u> | 0.00                 |         |        |              |               |               | <b>DAS</b><br><b>43</b><br><b>9-89</b> |                    |
| <b>*130*</b>                   |                                                     |                      |         |        |              | <u>6</u>      |               |                                        |                    |
| Packaging                      | Memo                                                | 0.00                 |         |        |              |               |               |                                        |                    |
| Packaging                      | LOCATION: WA004                                     |                      |         |        |              |               |               |                                        | <b>AUG 20 2015</b> |
| 140                            | QC21- Final Inspection - Work Order Release         | 0.00                 |         |        |              |               |               |                                        |                    |
| <b>*140*</b>                   |                                                     |                      |         |        |              |               |               |                                        | <b>AUG 20 2015</b> |
| QC                             | Memo                                                | 0.00                 |         |        |              |               |               |                                        |                    |
| Quality Control                |                                                     |                      |         |        |              |               |               |                                        |                    |

20150820  
Sdt

Tuesday, August 18, 2015 8:18:56 AM

**\*135718\***

**\*D4035-043\***

**Required Date:** 8/18/2015

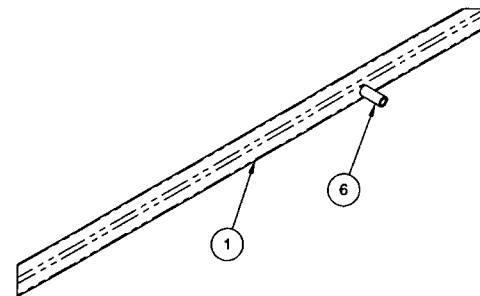
**Required Qty: 6.00**

**Comments:** IPP revA: new issue DD 09.11.25 verified by:EC  
per dwg revA 10.03.15 verified by:EC  
PER DWG REV.pb2 DD VRF:JFS

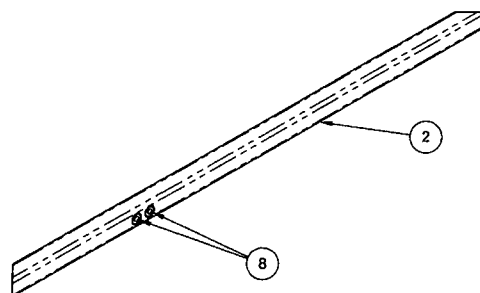
| Component Item ID/<br>Item Name                        | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand  | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued             | Status             |
|--------------------------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------------------|--------------------|
| D4021-9                                                |                        | Manufactured  | No          |                     |                  | 100             | Each               | 96.0000         | 2           | 12           |               | <b>DAS<br/>43<br/>9-89</b> | <b>AUG 18 2015</b> |
| <b>*D4021-9*</b><br>Bushing                            |                        |               |             |                     |                  |                 |                    |                 |             |              |               |                            |                    |
|                                                        |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  |                    | <u>Loc Code</u> |             |              |               |                            |                    |
|                                                        |                        |               |             | WA004               |                  | 96              |                    |                 |             |              |               |                            |                    |
|                                                        |                        |               |             | 120334              |                  | 2               |                    |                 |             |              |               |                            |                    |
|                                                        |                        |               |             | 122601              |                  | 4               |                    |                 |             |              |               |                            |                    |
|                                                        |                        |               |             | 133449              |                  | 40              |                    |                 |             |              |               |                            |                    |
|                                                        |                        |               |             | 134919              |                  | 50              |                    |                 |             |              |               |                            |                    |
| M304TS0.750W.049                                       |                        | Purchased     | No          |                     |                  | 100             | f                  | 807.5594        | 1.75        | 11.05263     |               | <b>DAS<br/>43<br/>9-89</b> | <b>AUG 18 2015</b> |
| <b>*M304TS0 750W 049*</b><br>304 SQ Tube .75x.75x.049W |                        |               |             |                     |                  |                 |                    |                 |             |              |               |                            |                    |
|                                                        |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  |                    | <u>Loc Code</u> |             |              |               |                            |                    |
|                                                        |                        |               |             | WA004               |                  | 807.5594        |                    |                 |             |              |               |                            |                    |
|                                                        |                        |               |             | M130871             |                  | 50.4            |                    |                 |             |              |               |                            |                    |
|                                                        |                        |               |             | M131128             |                  | 18.175          |                    |                 |             |              |               |                            |                    |
|                                                        |                        |               |             | M131868             |                  | 149.5           |                    |                 |             |              |               |                            |                    |
|                                                        |                        |               |             | M132744             |                  | 589.4844        |                    |                 |             |              |               |                            |                    |

| ITEM | QTY<br>-041 | QTY<br>-043 | QTY<br>-045 | QTY<br>-047 | P/N       | DESCRIPTION               |
|------|-------------|-------------|-------------|-------------|-----------|---------------------------|
|      | X           |             |             |             | D4035-041 | LID RIB ASSY, FWD         |
|      |             | X           |             |             | D4035-043 | LID RIB ASSY, AFT         |
|      |             |             | X           |             | D4035-045 | LID RIB ASSY, FWD (LIGHT) |
|      |             |             |             | X           | D4035-047 | LID RIB ASSY, AFT (LIGHT) |
| 1    | 1           |             |             |             | D4035-1   | RIB                       |
| 2    |             | 1           |             |             | D4035-3   | RIB                       |
| 3    |             |             | 1           |             | D4035-5   | RIB                       |
| 4    |             |             |             | 1           | D4035-7   | RIB                       |
| 5    |             |             |             | 2           | D4035-11  | BUSHING                   |
| 6    | 1           |             |             |             | D2327-3   | SPACER BUSHING            |
| 7    |             |             | 1           |             | D2953-175 | SPACER                    |
| 8    |             | 2           |             |             | D4021-9   | BUSHING                   |

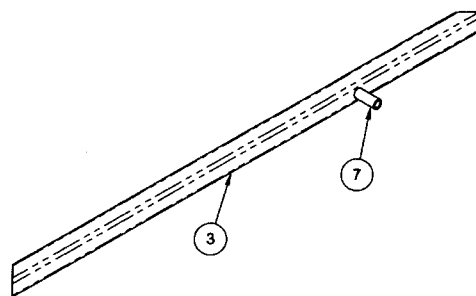
135718 MGS  
 150818



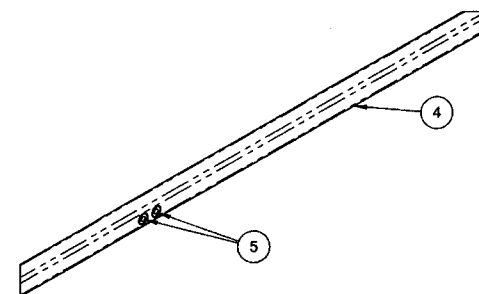
**D4035-041 BASKET LID RIB ASSY, FWD**



**D4035-043 BASKET LID RIB ASSY, AFT**



**D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)**

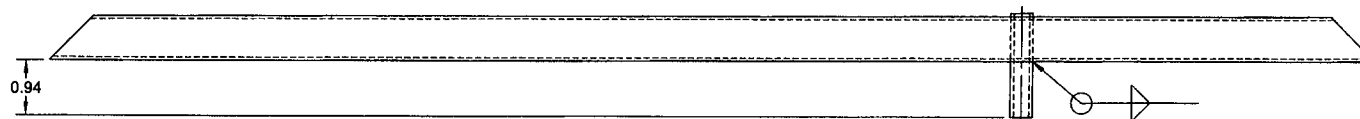


**D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)**

RELEASED  
 2010-03-12

|            |             |                                                                                                                                                                                                                                                                            |              |
|------------|-------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| A          | NEW ISSUE   | JPH                                                                                                                                                                                                                                                                        | 10.03.04     |
| REV.       | DESCRIPTION | BY                                                                                                                                                                                                                                                                         | DATE         |
| DESIGN     | AJS         | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                          |              |
| DRAWN      | JPH         | DRAWING NO.                                                                                                                                                                                                                                                                | REV. A       |
| CHECKED    |             | D4035                                                                                                                                                                                                                                                                      | SHEET 1 OF 5 |
| MFG. APPR. |             | TITLE                                                                                                                                                                                                                                                                      | SCALE        |
| APPROVED   |             | BASKET LID RIB ASSY                                                                                                                                                                                                                                                        | NTS          |
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| DATE       | 10.03.04    |                                                                                                                                                                                                                                                                            |              |

8 7 6 5 4 3 2 1



D4035-1  
RIB

D2327-3  
SPACER BUSHING

**D4035-041 BASKET LID RIB ASSY, FWD**



D4035-3  
RIB

D4021-9  
BUSHING  
2 PL

G  
G  
TYP

**D4035-043 BASKET LID RIB ASSY, AFT**

**RELEASED**  
2010-03-12  
W.D.

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.83 lbs
- 8) WELDING: PER DART QSI 004

|            |          |                                                                                                                                                                                                                                                                                         |              |
|------------|----------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | AJS      | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                |              |
| DRAWN      | JFH      |                                                                                                                                                                                                                                                                                         |              |
| CHECKED    |          | DRAWING NO.                                                                                                                                                                                                                                                                             | REV. A       |
| MFG. APPR. |          | <b>D4035</b>                                                                                                                                                                                                                                                                            | SHEET 2 OF 5 |
| APPROVED   |          | TITLE                                                                                                                                                                                                                                                                                   | SCALE        |
| DE APPR.   |          | <b>BASKET LID RIB ASSY</b>                                                                                                                                                                                                                                                              | NTS          |
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8 7 6 5 4 3 2 1

D4035-5  
RIB

D2953-175  
SPACER

0.94

**D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)**

D4035-7  
RIB

D4035-11  
BUSHING  
2 PL

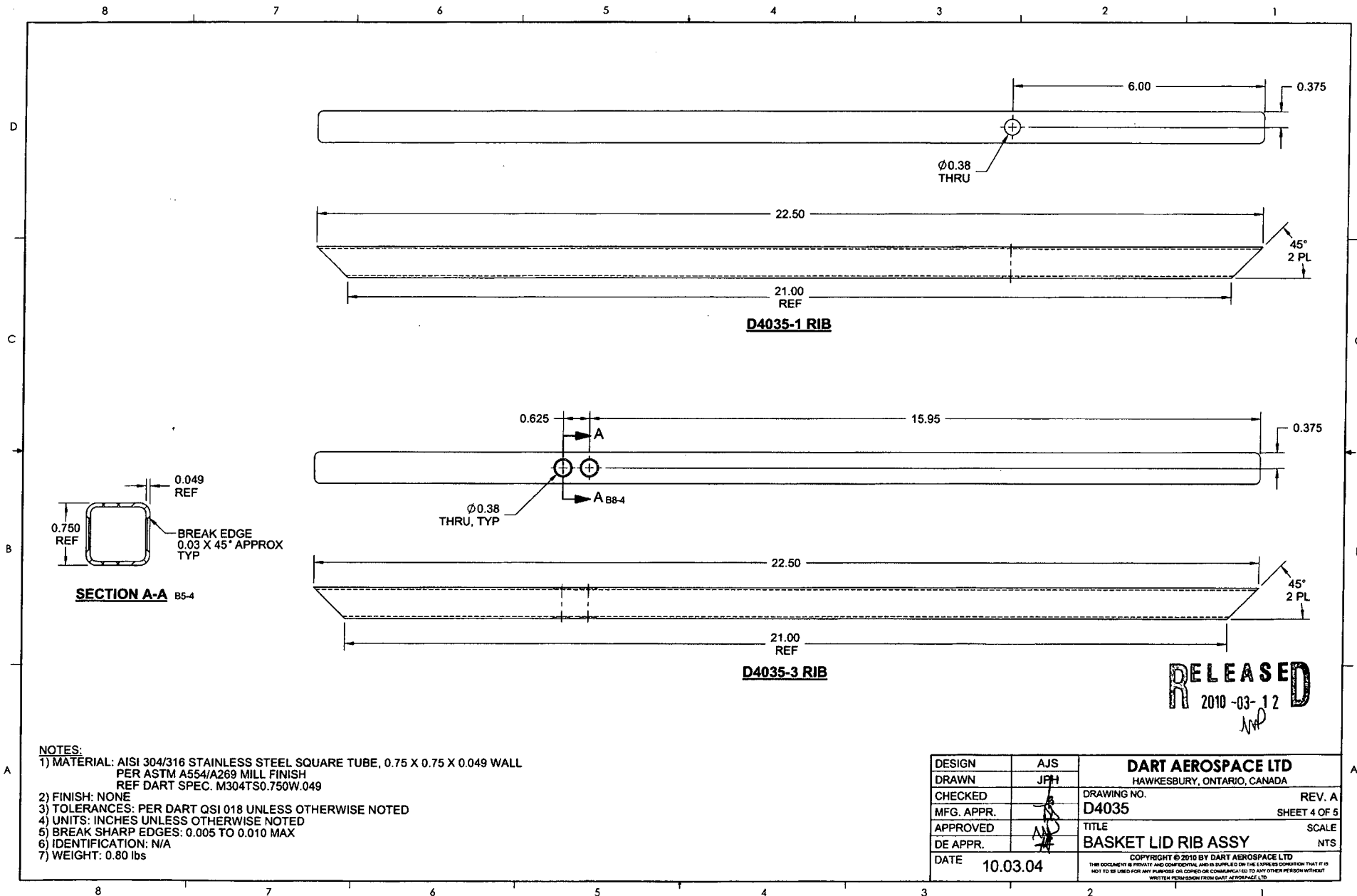
**D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)**

**RELEASED**  
2010-03-12

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs
- 8) WELDING: PER DART QSI 004

|            |                    |                                                                                                                                                                                                                                                                                                   |        |
|------------|--------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------|
| DESIGN     | AJS                | <b>DART AEROSPACE LTD</b>                                                                                                                                                                                                                                                                         |        |
| DRAWN      | JPH                | HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                                                       |        |
| CHECKED    | <i>[Signature]</i> | DRAWING NO.<br><b>D4035</b>                                                                                                                                                                                                                                                                       | REV. A |
| MFG. APPR. | <i>[Signature]</i> | SHEET 3 OF 5                                                                                                                                                                                                                                                                                      |        |
| APPROVED   | <i>[Signature]</i> | TITLE                                                                                                                                                                                                                                                                                             | SCALE  |
| DE APPR.   | <i>[Signature]</i> | <b>BASKET LID RIB ASSY</b>                                                                                                                                                                                                                                                                        | NTS    |
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2010-03-12

|                                                                                                                                                                                                                                |          |                                        |              |
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| DRAWN                                                                                                                                                                                                                          | JPH      | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED                                                                                                                                                                                                                        |          | DRAWING NO.                            | REV. A       |
| MFG. APPR.                                                                                                                                                                                                                     |          | <b>D4035</b>                           | SHEET 4 OF 5 |
| APPROVED                                                                                                                                                                                                                       |          | TITLE                                  | SCALE        |
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